

Date: Monday, 23/03/2009 1:31:59 PM
 User: Julie Dawson

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : 206B BASKET LID
 Job Number : 45977A
 Estimate Number : 11280
 P.O. Number :
 This Issue : 23/03/2009 S.O. No. :
 Prsht Rev. : NC Part Number : D2330043
 First Issue : / / Type : LARGE FAB ASSY Drawing Number : D2330 REV.G
 Previous Run : 44222A Project Number : N/A
 Material :
 Due Date : 30/04/2009 Qty: 1 Um: Each
 Written By :
 Checked & Approved By : JUD 09-03-23
 Comment : Est Rev:H 02.09.04 M304EX0.75-16F was M750-16FXS-S/S K
 J
 Est Rev:I 08-09-09 revF as per dwg (ecn 08-522) DD verified
 by:EC

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 M304TS0750W065 304 SQ Tube .75x.75x.065W



Comment: Qty.: 30.2568 f(s)/Unit Total : 30.2568 f(s)

3/4" x 3/4" x 0.065 wall 304/316 SS tubing.

Batch: 2211148

SAD 09-03-31

2.0 LARGE FAB 1 LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1- Cut D2330-1-3-9 as per Dwg D2330

2-Drill hole in D2330-3 as per Dwg D2330

3-Deburr

SAD 09-03-31

3.0 D22521 Frame



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Frame

batch: _____

N/A

4.0 D22527 Frame



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Frame

batch: _____

N/A

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 23/03/2009 1:31:59 PM
User: Julie Dawson

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206B BASKET LID

Job Number: 45977A

Part Number: D2330043

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

D23273

Spacer Bushing



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Bushing

batch: B39560

Cpl 09.04.06

6.0

D2329

Label Plate



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Label Plate

batch: B35686

Cpl 09.04.06

7.0

D23301

Frame



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Frame

batch: _____

N/A

8.0

D233015

Frame



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Frame

batch: _____

N/A

9.0

D2581

Mounting Bracket



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Mounting Chanel

batch: B45684

Cpl 09.04.06

10.0

D37491

Hinge Half



Comment: Qty.: 3.0000 Each(s)/Unit Total : 3.0000 Each(s)

Hinge Half

batch: B38826

Cpl 09.04.06

11.0

M304EX07516F

Expanded Metal Flat SS



Comment: Qty.: 18.9000 sf(s)/Unit Total : 18.9000 sf(s)

Pick:

Qty Part Number Description Batch

18 sf M304EX0.75-16F Expanded Metal M11173

Cpl 09.04.06

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 23/03/2009 1:32:00 PM
User: Julie Dawson

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206B BASKET LID

Job Number: 45977A

Part Number: D2330043

Job Number:



Seq. #:

Machine Or Operation:

Description :

12.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1-Weld as per Dwg D2330 using Welding Table and corner Jig

Deburr as required

A/R SS ROD

Batch: M106762

PD 09-04-06

13.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

PD 09-04-07

14.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

PD 09-06-07 (1)

15.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

1st coat 8:20 OF

START TIME:

OVEN TEMPERATURE: 400

FINISH TIME: 8:50

2nd coat start time: 9:00
oven temp: 400 OF
finish time: 9:30

M 110939 M 09/04/11

16.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

BR 09-04-13 (1)

17.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

DP 45977 9/6/4

(10)

SM

18.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

09/06/05

Job Completion



MF 09-06-04

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

ITEM	QTY -041	QTY -043	PART NUMBER	DESCRIPTION
1	X		D2330-041	BASKET ASSEMBLY
3		X	D2330-043	LID ASSEMBLY
7	1		D2012-107	CLEVIS
8	4		D2235-1	RIB
9	2	2	D2252-1	FRAME
10	1	4	D2252-7	FRAME
11	2		D2253-1	LUG
12	2		D2254	GUSSET
13	1	1	D2327-3	BUSHING
14		1	D2329	LABEL PLATE
15	2	2	D2330-1	FRAME
16	1		D2330-5	FRAME
17	1		D2330-7	FRAME
18		1	D2330-15	FRAME
19	4	2	D2581	MOUNTING CHANNEL
20	3		D3748-1	HINGE HALF
21		3	D3749-1	HINGE HALF

G

G

G

G

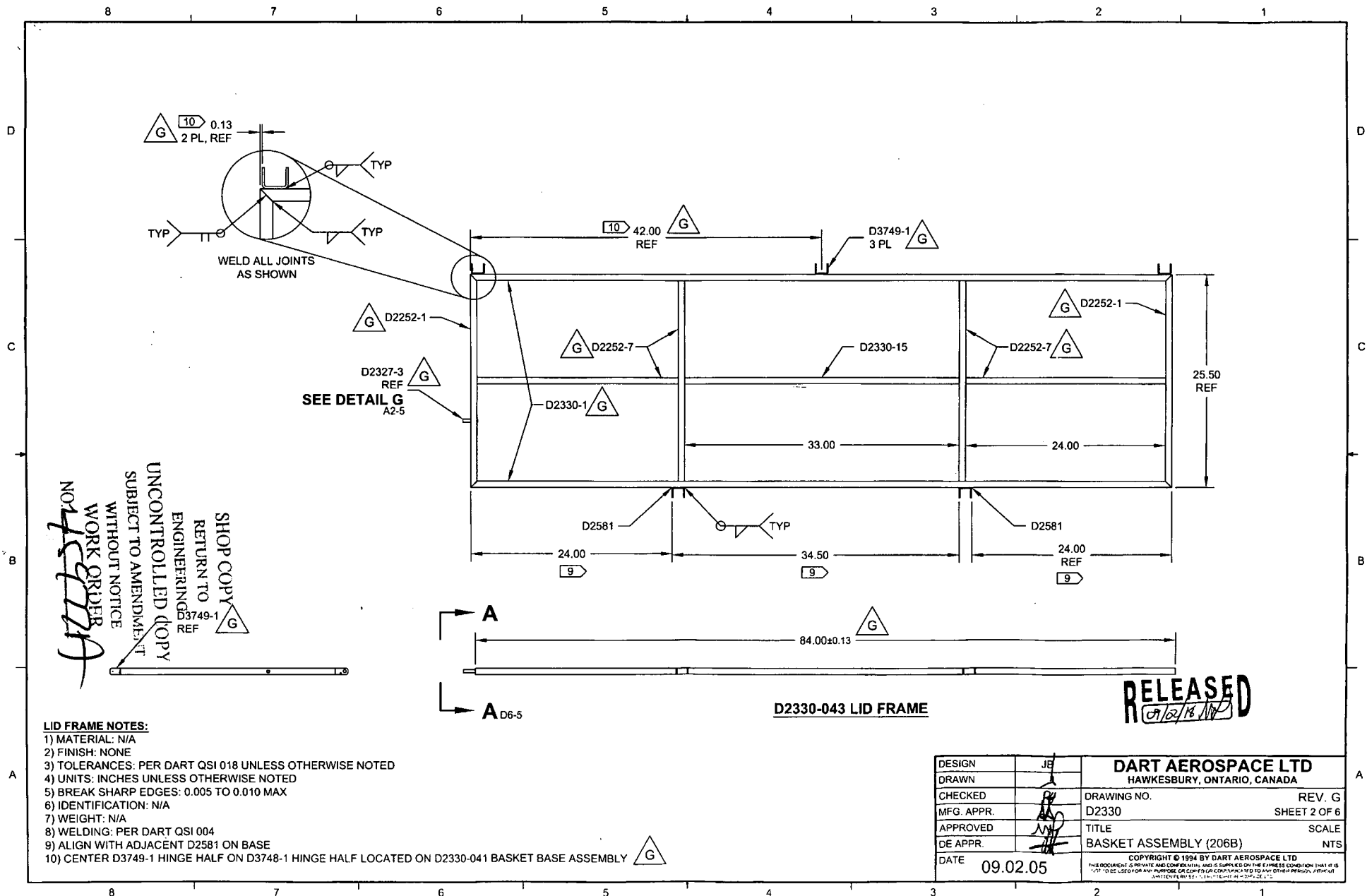
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9/2/84

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WORK ORDER
NO. 45977A

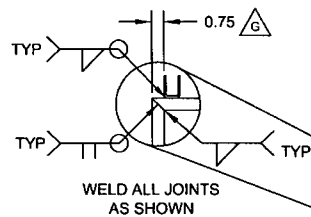
NOTES:

- 1) FRAME MATERIAL: AISI 304/316 SS, 3/4 x 3/4 x 0.065 WALL SQUARE TUBING
REF. DART SPEC M304TS0.750W.065
- 2) MESH MATERIAL: 3/4-16F EXPANDED SS
REF DART SPEC M304EX0.75-16F
- 3) FINISH: POWDER COAT ASSEMBLY GLOSS WHITE (4.3.5.2) PER DART QSI 005 4.3
- 4) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) UNITS: INCHES UNLESS OTHERWISE NOTED
- 6) BREAK SHARP EDGES: N/A
- 7) IDENTIFICATION: N/A
- 8) WEIGHT: N/A
- 9) WELDING: PER DART QSI 004

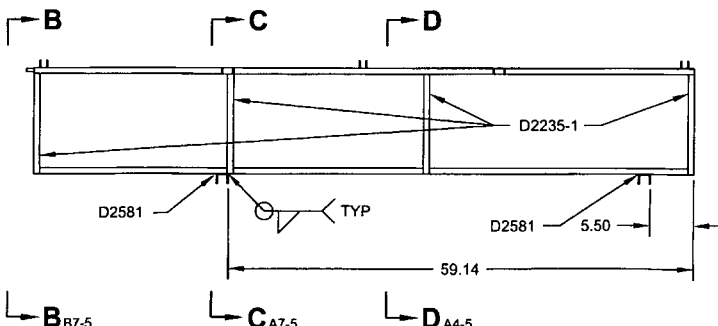
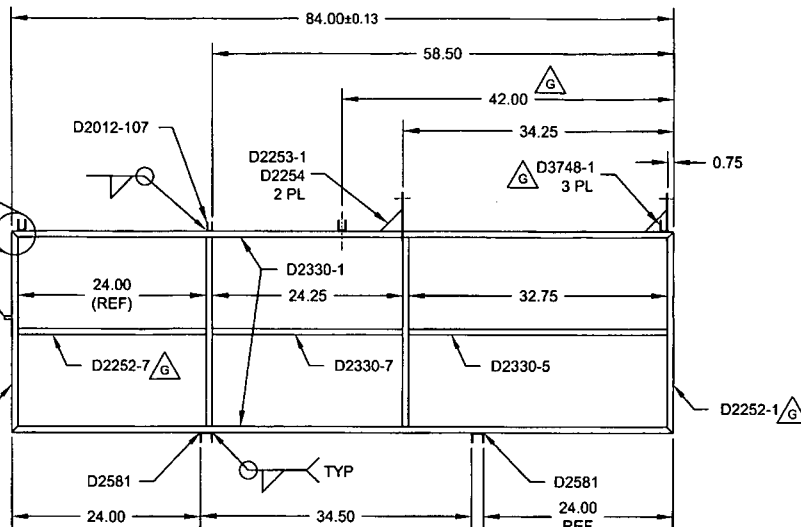
G	ADDED 'ITEM' COLUMN TO PARTS LIST; ADDED NOTE 10 ON SHT 2; ITEMS 20 AND 21 REPLACE D2232-1/-3; STRETCHED LID FROM 83.27" TO 84.00"; ITEMS 9 & 10 REPLACE D2330-3/-9/-13; ITEM 13 (ON LID) REPLACES D2327-1; REORGANIZED ALL SECTION & DETAIL VIEWS. REASON: SEE PAR#09-006.	MB	09.02.05
F	DRAWING UPDATED TO CURRENT STANDARDS. SHEET 6 ADDED. FRAME MATERIAL THICKNESS WAS 0.060.	AJS	08.08.11
E	INCORPORATED D1. D2253-1 WAS D2253 (NCR 533).	KE	05.11.10
D	MODIFIED LATCH, REDRAWN	KE	99.09.14
C	ADDED LATCH AND LABEL PLATE	BK	96.05.23
REV.	DESCRIPTION	BY	DATE
DESIGN	JB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	J		
CHECKED	W		
MFG. APPR.	W		
APPROVED	W		
DE APPR.	W	DRAWING NO.	REV. G
DATE	09.02.05	D2330	SHEET 1 OF 6
		TITLE	SCALE
		BASKET ASSEMBLY (206B)	NTS
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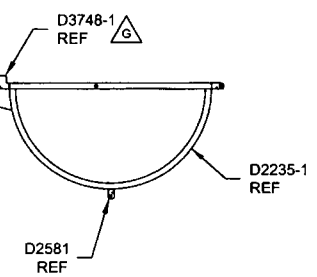
8 7 6 5 4 3 2 1



SEE DETAIL G
D2327-3 REF
A2-5








D2330-041 BASE FRAME ASSEMBLY



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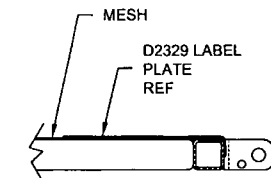
BASE FRAME NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: N/A
- 8) WELDING: PER DART QSI 004

DESIGN	JB	DART AEROSPACE LTD	
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CHECKED		DRAWING NO.	REV. G
MFG. APPR.		D2330	SHEET 3 OF 6
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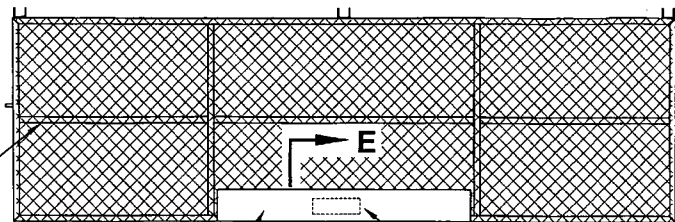
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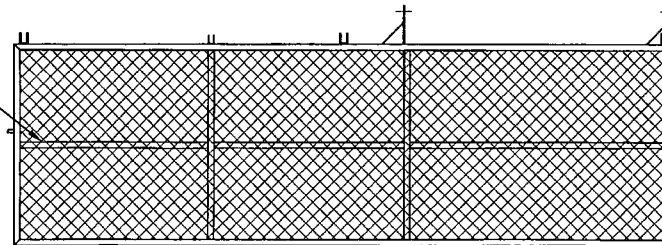


SECTION E-E C3-4
VIEW ROTATED 90° CCW

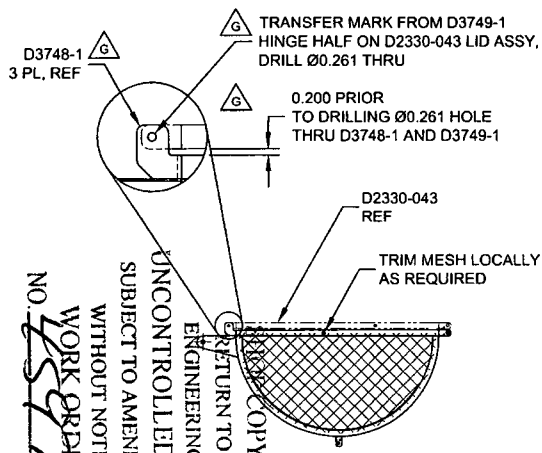
TACK WELD EACH
STRAND END OF
MESH TO FRAME



D2330-043 LID ASSEMBLY



D2330-041 BASE ASSEMBLY



ASSEMBLY NOTES:

- 1) MATERIAL: SEE SHEET 1 FOR MESH MATERIAL
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: N/A
- 8) WELDING: PER DART QSI 004

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8

7

6

5

4

3

2

1

D

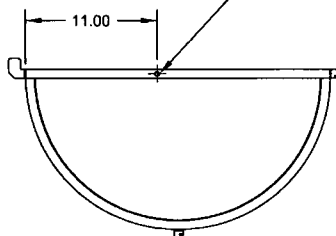
C

B

A

**VIEW A-A** A6-2

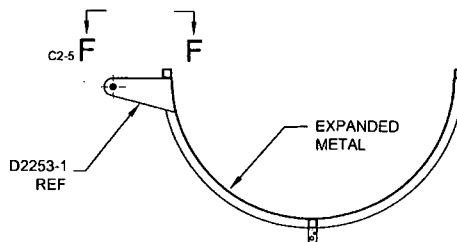
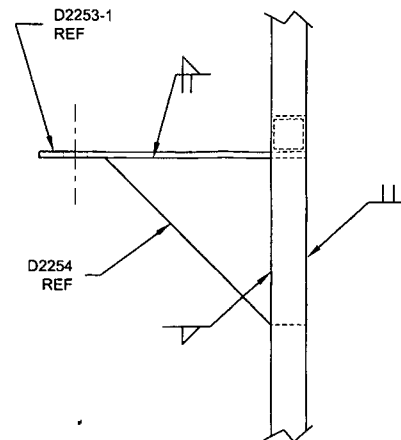
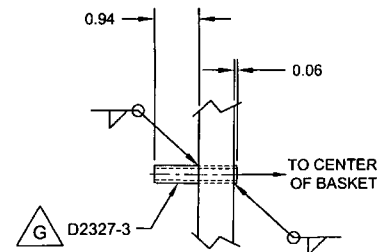
DRILL 3/8 HOLE AND
INSTALL D2327-3
SEE DETAIL G A2-5

**VIEW B-B** A5-3D2581
REF

NO
WORK ON
THIS
DRAWING
WITHOUT
NOTICE
FROM
ENGINEERING
RETURN TO
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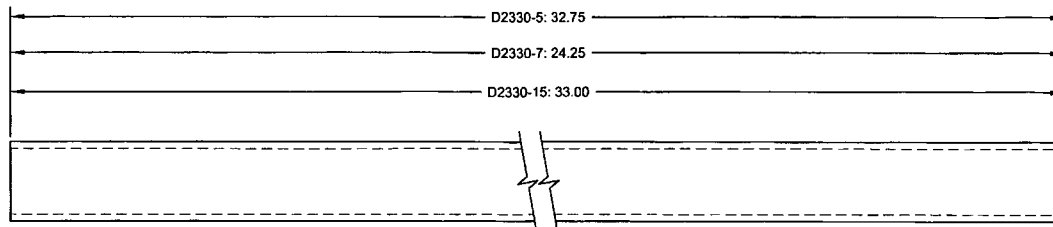
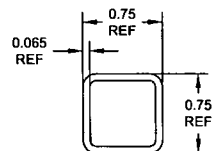
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NOTICE

WELD D2581
WITH LARGE HOLE
ON THIS SIDE

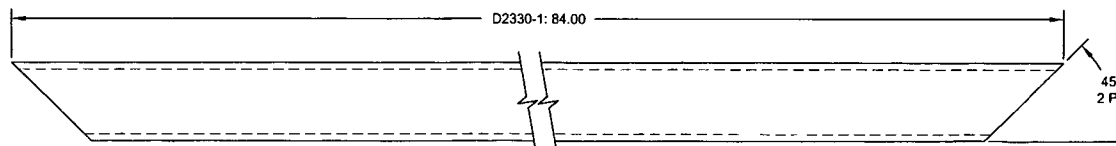
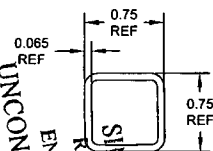
SECTION C-C A4-3D2581
REFEXPANDED
METAL**SECTION D-D** A3-3D2253-1
REFEXPANDED
METAL**VIEW F-F** B6-5
SCALE 4X**DETAIL G**
SPACER INSTALLATION
SCALE 4XC6-2
C5-3
C6-5

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MFG. APPR.		D2330	SHEET 5 OF 6
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RELEASED
2/26/18



D2330-5 FRAME
D2330-7 FRAME
D2330-15 FRAME



D2330-1 FRAME

RELEASED
09/02/05

NOTES:

- 1) FRAME MATERIAL: SEE SHEET 1
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: N/A

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MFG. APPR.		D2330	SHEET 6 OF 6
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